

# Work Order ID 68045

Tuesday, April 05, 2011 3:13:34 PM



Page 1

Item ID: D4277-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*H*

Date: *11-04-05*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4277

D

100

0.00



Large Fab

Large Fab

Memo

1- Cut tube as per dwg D4277  
2- Remove marking, deburr

0.00

*SAD 11-04-05*

*(1)*

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

Quality Control

0.00

*CPL 11-04-06*

120

Identify as per dwg & Stock Location:

*B/c*

0.00



Packaging

Memo

\*\*\*STOCK IN BASKET CELL\*\*\*

0.00

*CPL 11-04-06*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 68045

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/6

MF  
11-04-06

W/O:		WORK ORDER CHANGES						
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# Picklist Print

Tuesday, April 05, 2011 3:13:39 PM

Page 1

Work Order ID: 68045

Parent Item: D4277-9

Parent Item Name: Rib



Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

3.0736

1.125

1.184211



SAD 11-04-05

Square Tubing

Location

Loc Qty

Loc Code

MAT034

3.0736

116610

3.0736

1.1843  
+ ,2000 EMO Scrap  
1,3843

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68045

*AP 11-04-5*

D4277-1 RIB

D4277-3 RIB

D4277-5 RIB

D4277-7 RIB

D4277-9 RIB

D4277-11 RIB

D4277-19 RIB

RELEASED  
2011-02-24  
*MP*

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV - 13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -8: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 28.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4277</b> TITLE <b>RIBS</b>  DATE <b>11.02.09</b>	
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
		REV. D	SHEET 1 OF 3
		SCALE	NTS
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W/O:		WORK ORDER CHANGES						
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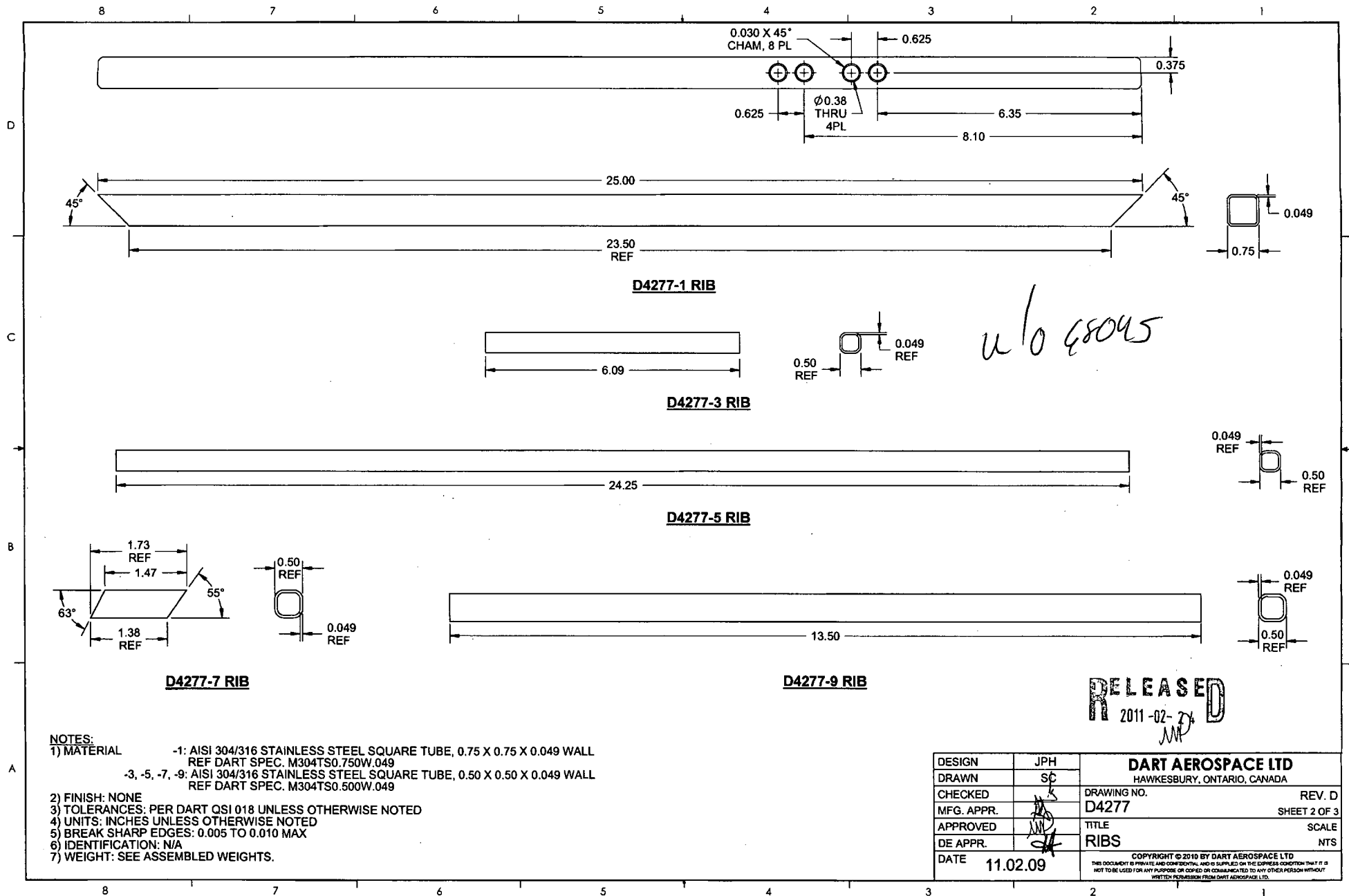
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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MFG. APPR.	MD	D4277	SHEET 2 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	SK	RIBS	NTS
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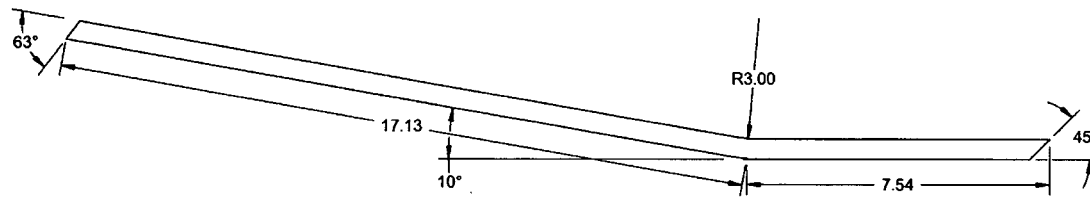
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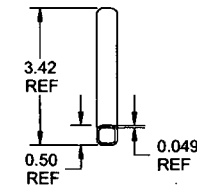
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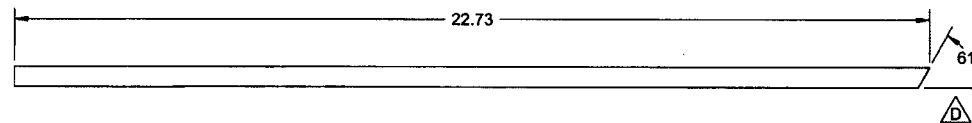
**NOTE:** Date & initial all entries



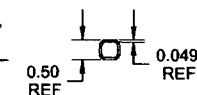
**D4277-11 RIB**



*W/ 6804S*



**D4277-19 RIB**



**NOTES:**

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

**RELEASED**  
2011-02-24

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DRAWN	SC		
CHECKED	K	DRAWING NO.	REV. D
MFG. APPR.		<b>D4277</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIBS</b>	NTS
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